

Work Order ID 52550

September 30, 2009 10:24:57 AM



Page 1

Item ID: D3656-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/09/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PP

Date: 09-9-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3656	Rev B								
100	HAND FINISHING THERMOFORMING	0.00							
	Thermoform	Memo							
	Thermoforming Machine	Cut Blanks to fit frame size							
110	THERMOFORMING MACHINE	0.00							
	Thermoform	Memo							
	Thermoforming Machine	Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986							
		Dwg. Rev. <u>B</u> Folio Rev. <u>A</u>							
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo							
	Quality Control	Visually inspect for proper formation of each part							

BB 09/10/14
X6

BB 09/10/14
X6

BB 09/10/14
X6

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Item ID: D3656-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/09/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DL 09/10/14
x16

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3656

DL 09/10/14
x16

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

DL 09/10/14
x16

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Stop



Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/09/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8 or 10/13			(X6)	/		
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				9/10/19 60 20			
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/10/20 70 20 MF 09-10-20			

Picklist Print

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Work Order ID: 52550



Parent Item: D3656-1RevB



Parent Item Name: PANEL

Start Date: 30/09/2009

Required Date: 30/09/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.812	128.0000			

GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1385.812653

107574

16.62

111973

190.526053

112176

1178.6666

6

BB 09/10/14

DART AEROSPACE LTD		Work Order:	52550
Description: Panel		Part Number:	D3656-1
Inspection Dwg: D3656	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB Date: 09/10/19

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070	Min	0.072	✓			
0.050	Min	0.051	✓			
24.7	REF	24.80	✓			
0.7	REF	0.70	✓			

Measured by: DK Date: 09/10/19
Audited by: BB Date: 09/10/19
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New issue	KJ/DL	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	

0.7
(BOTH SIDES, REF)

3.1 REF

1.1 REF

21.2 REF

MINIMUM THICKNESS = 0.070
(ENTIRE FLANGE, BOTH SIDES)

TEXTURED SURFACE
ON THIS SIDE

24.7 REF

16.5 REF

57.5 REF

MINIMUM THICKNESS = 0.050
(ALL OVER EXCEPT WHERE NOTED)

D3656-1 PANEL

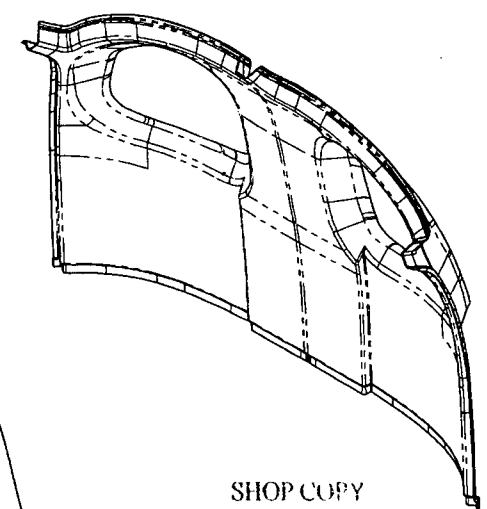
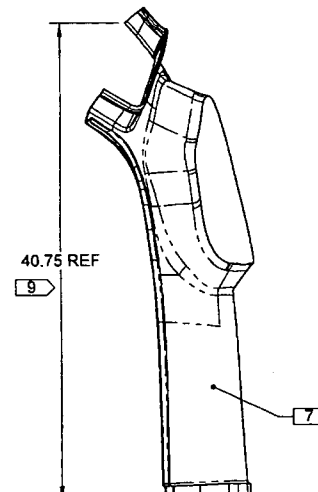
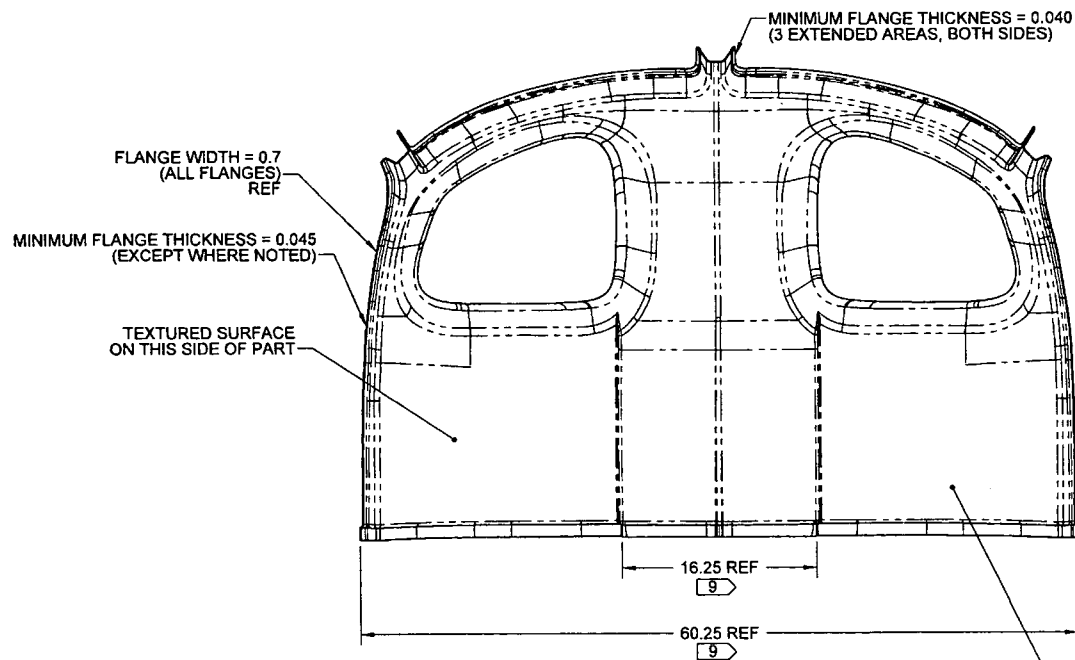
NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8986 PER QSI 022
TRIM PER DT8986
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.6 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

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08-09-30

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A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3656	SHEET 1 OF 2
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RELEASED
06-09-30
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D3656-3 PANEL

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8987 PER QSI 022
TRIM PER DT8987
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 6.7 lbs
- 9) DIMENSIONS TAKEN WITH PART IN MOLD WHERE INDICATED

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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